

Date: Tuesday, 22/04/2008 10:35:40 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH
 Job Number : 38731
 Estimate Number : 10268
 P.O. Number :
 This Issue : 22/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LANDING GEAR
 Previous Run : 38730
 Part Number : D350636014
 Drawing Number : D2750 REV E
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 15/05/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JLD 08.4.21
 Comment :
 Est Rev:H 02.09.25 Rearranged procedure steps KJ
 Est Rev:I 05.12.08 Rearranged procedure steps EC
 Est Rev:J 06.03.30 Per rev. D EC
 Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM
 Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014-CHG 003

CHG 004

800606/05

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B 38463

D M 8-4-30

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

337768

BE 08/05/01

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8864 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut

W/AWM
 8-4-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 10:35:40 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 38731

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

as per dwg D2750.

4-Drill pilot holes for Detail G using DT8329.

5-Open up holes for Detail B to 0.375 (2 holes per side) and blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297" ***Make sure that wearplate holes are on bottom of tube*** Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004.
A/R Aluminum Rod *m106330/m107263 BE 08/05/01*

10-Grind welds flush as per Dwg D2750 *SL 8-5-2*

11-Countersink Detail A as per dwg D2750.

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS *08/05/02*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *08/05/02*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *SL 8-5-5*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *08/05/02*

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch: *38464*

SL 8-5-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 10:35:40 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 38731

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

R33824 *BE* *08/05/12*

11.0

D34905

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

R32597 *BE* *08/05/12*

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch:

R37767 *BE* *08/05/12*

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes section T-T 0.500" (4 per side) as per dwg D2750

2-Open holes section V-V 0.3125" (4 per side)

3-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch: *107804*

exp. date: *8-7-31*

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 5)

A/R

Aluminum Rod

batch:

m107863 *BE* *08/05/12*

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

SL8-5-5

SL8-5-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 10:35:40 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 38731

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

10-Deburr holes

SL 85-12

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5 08/05/22 (40)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/22 (80)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FL 08/06/03 B.31 2008

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

BR 08-06-04

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

FL 08/06/04 (1)

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Insert

Batch:

M 100489

FL

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

FL 08/06/04 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/05/2008 11:56:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 38731

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch:

B36230

FL

22.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B38867

FL

23.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B38565

FL

24.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch:

B38254

FL

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch:

B39279

FL

26.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch:

B39277

FL

27.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch:

B39276

FL 08/06/04 ①

Date: Friday, 16/05/2008 11:56:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 38731

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Gasket

B39361

FL

29.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Wearshoe

B39479

FL

30.0

D36721

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Phenolic Washer

B39275

FL

31.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Screw

m108062

FL

32.0

AN526C1032R18

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Screw

m108079

FL

33.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
WASHER

Batch: B38139

FL

34.0

D3488042

Blade Fitting Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Blade Fitting, RH

Batch: D38466

FL

35.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
PLUG ASSEMBLY

Batch: D38756

FL 08/06/04

①

Date: Friday, 16/05/2008 11:56:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 38731

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

36.0	D3492045	Plug Assembly
------	----------	---------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PLUG ASSEMBLY
Batch: B33435

FL

37.0	AN3C5A	Bolt
------	--------	------



Comment: Qty.: ³⁴~~138~~ 0.0000 Each(s)/Unit Total : ³⁴~~138~~ 0.0000 Each(s)
Bolt
Batch: m107862

FL

38.0	AN3C6A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: m105300

FL

39.0	AN3C7A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT
Batch: _____

[Large handwritten signature across rows 39.0 and 40.0]

40.0	AN6C44A	BOLT
------	---------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT
Batch: m107685

FL

41.0	AN8C35A	BOLT
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT
Batch: m106896

FL

42.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: ³⁸~~46~~ 0.0000 Each(s)/Unit Total : ³⁸~~46~~ 0.0000 Each(s)
washer
Batch: m108077

FL 08/06/04 (1)

Date: Friday, 16/05/2008 11:56:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 38731

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

AN960C816L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WASHER

Batch: m107520

FL

44.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: m107736

FL

45.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: m107939

FL

46.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: m107394

FL

47.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: _____

m107804
exp. date: 08/10

48.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble tube hardware as per dwg D2750

sikaflex batch: m107804

exp. date: 08/10

2-Inspect For Foreign Objects

3-Spray inside of tube with "LPS-3"

batch: m106096

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: m107804

FL 08/06/04 (1)

Date: Friday, 16/05/2008 11:56:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 38731

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

EXP DATE: 08/10

5-Coat all exposed fasteners with "LPS Procyon" batch: M104251

FL 08/06/04

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/05

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

51.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 30343

AS 08/06/05

52.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107520

AS 08/06/05

53.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M107939

AS 08/06/05

54.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107924

AS 08/06/05

Date: Friday, 16/05/2008 11:56:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 38731

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M67581

AS 08/06/05 (2)

56.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B38102

AS 08/06/05 (2)

57.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/06/05 (2)

58.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

G 08/06/05 (1)

59.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/06/06 (1)

Job Completion



W 08/06/06

38731

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

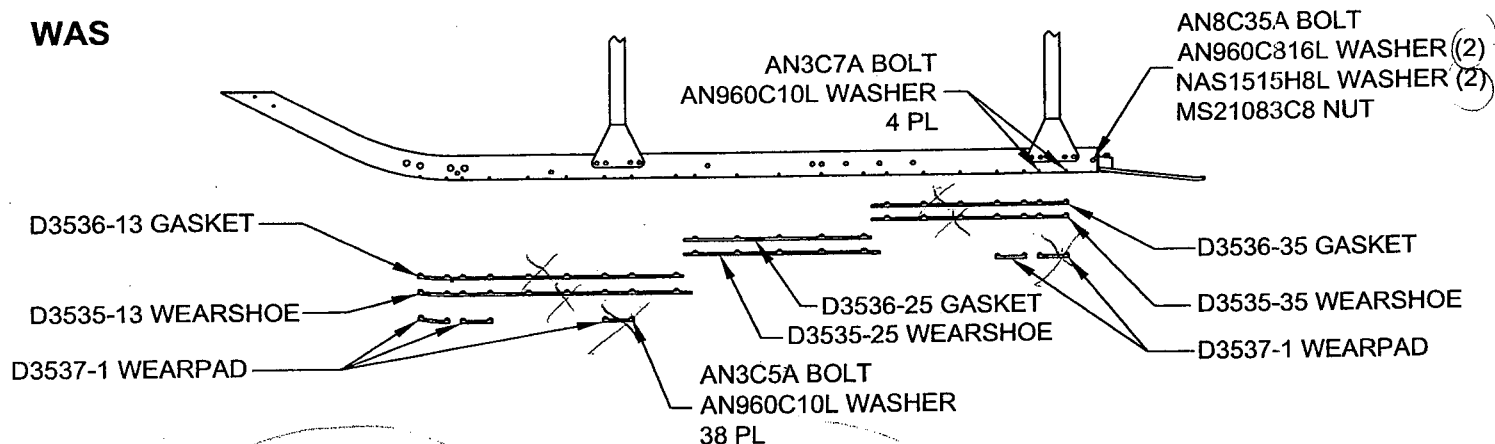
REF CANADIAN STC: SH99-7

FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004:

TO IMPROVE THE INSTALLATION OF THE DART D350-636-011/-012/-013/-014 SKIDTUBES ONTO THE CROSSTUBES, THE INSTALLATION AND PART NUMBERS OF THE FWD AND AFT WEARSHOES/GASKETS HAVE BEEN REVISED AS SHOWN IN FIGURE 1 BELOW.

FOR EXISTING CUSTOMERS THAT WOULD LIKE TO IMPROVE THE INSTALLATION OF THE SKIDTUBE TO THE CROSSTUBE, REFER TO PAGE 3 OF THIS DOCUMENT

WAS



NOW

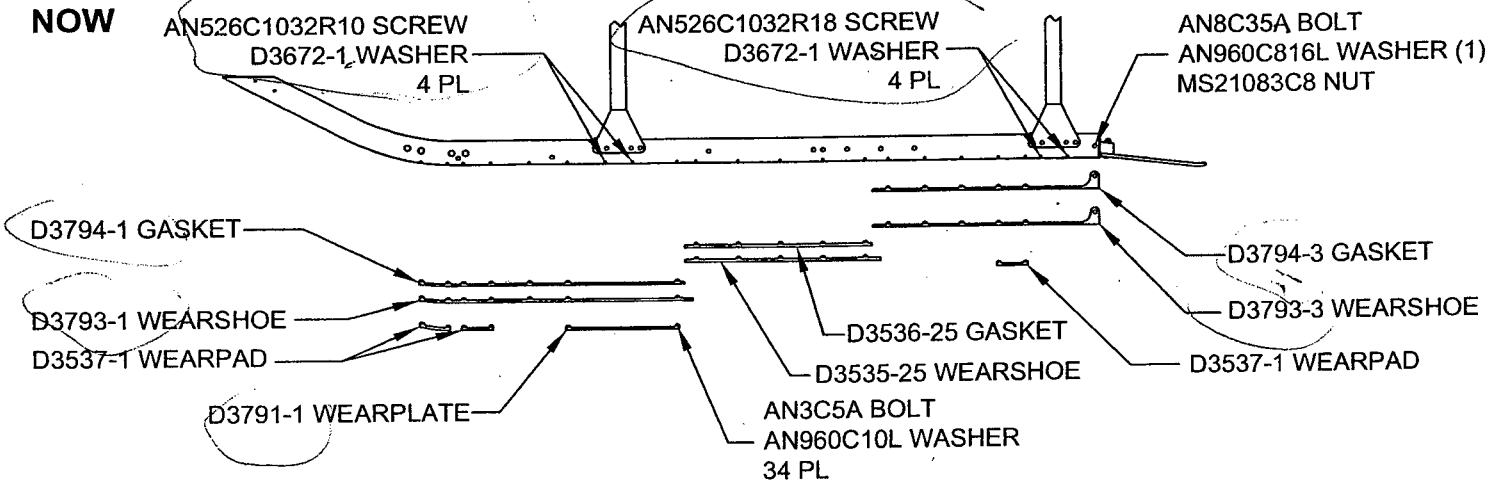
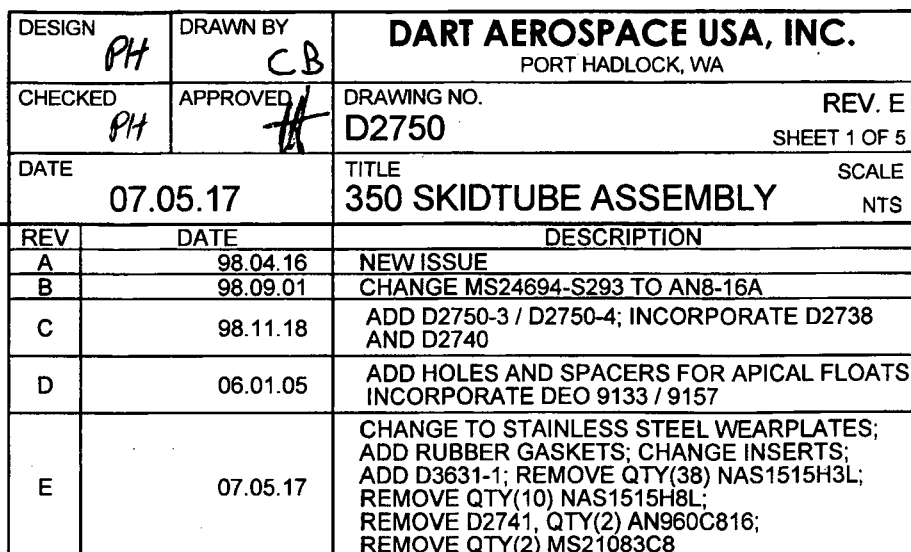


FIGURE 1 - D350-636-011/-012/-013/-014 AT CHG 004 AND INSTALLATION OF DSI 9413-011
(LOCATION OF AN526C1032RXX SCREWS ARE NOT TO BE USED TO MOUNT WEARSHOES)

PRELIMINARY ISSUE

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	A	DRAWING NO.	REV. A
MFG. APPR.		DSI 9413	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE INSTALLATION	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



RELEASED
07-08-02

Qty -Q41	Qty -Q42	Qty -Q43	Qty -Q44	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38731

COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 2 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

RELEASED
07-08-02 [Signature]

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS POWDER COATING WITH MEK DEGREASER.

SHOP COPY
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *3813*

COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Date: Tuesday, 22/04/2008 10:35:40 AM
 User: Julie Lecocq

Process Sheet

20

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH
 Job Number : 38731
 Estimate Number : 10268
 P.O. Number :
 This Issue : 22/04/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D350636014
 First Issue : / / Type : LANDING GEAR Drawing Number : D2750 REV E
 Previous Run : 38730 Project Number : N/A
 Material :
 Due Date : 15/05/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 08.4.21
 Comment :
 Est Rev:H 02.09.25 Rearranged procedure steps KJ
 Est Rev:I 05.12.08 Rearranged procedure steps EC
 Est Rev:J 06.03.30 Per rev. D EC
 Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM
 Verified By:EC

REFERENCE ONLY

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 003

2.0	D26003BENT	Extrusion Bent
-----	------------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

3.0	D2744	Cap
-----	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: _____

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8864 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut

NO. 153

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 38543
Part number: D350 636 011
Description: Skid tube 350
Welding Process: Tig[☒] Mig[]
Base materiel: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

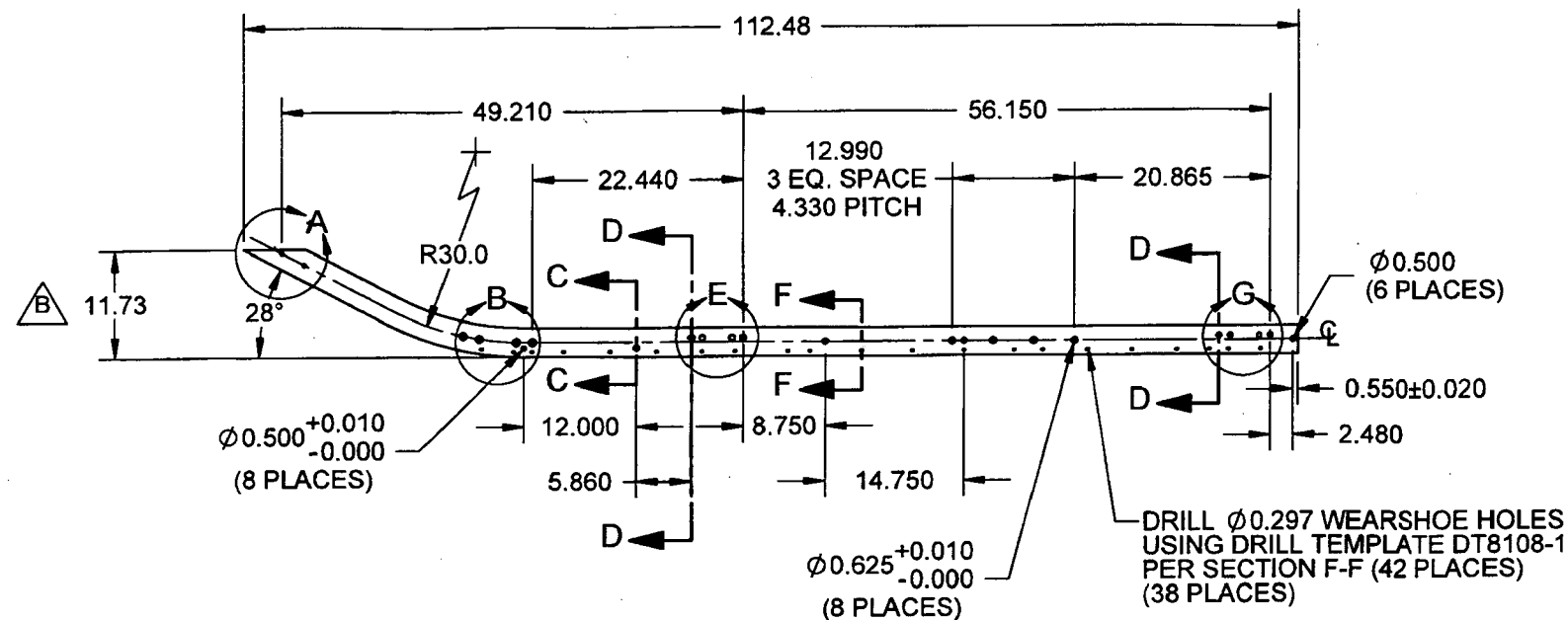
Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

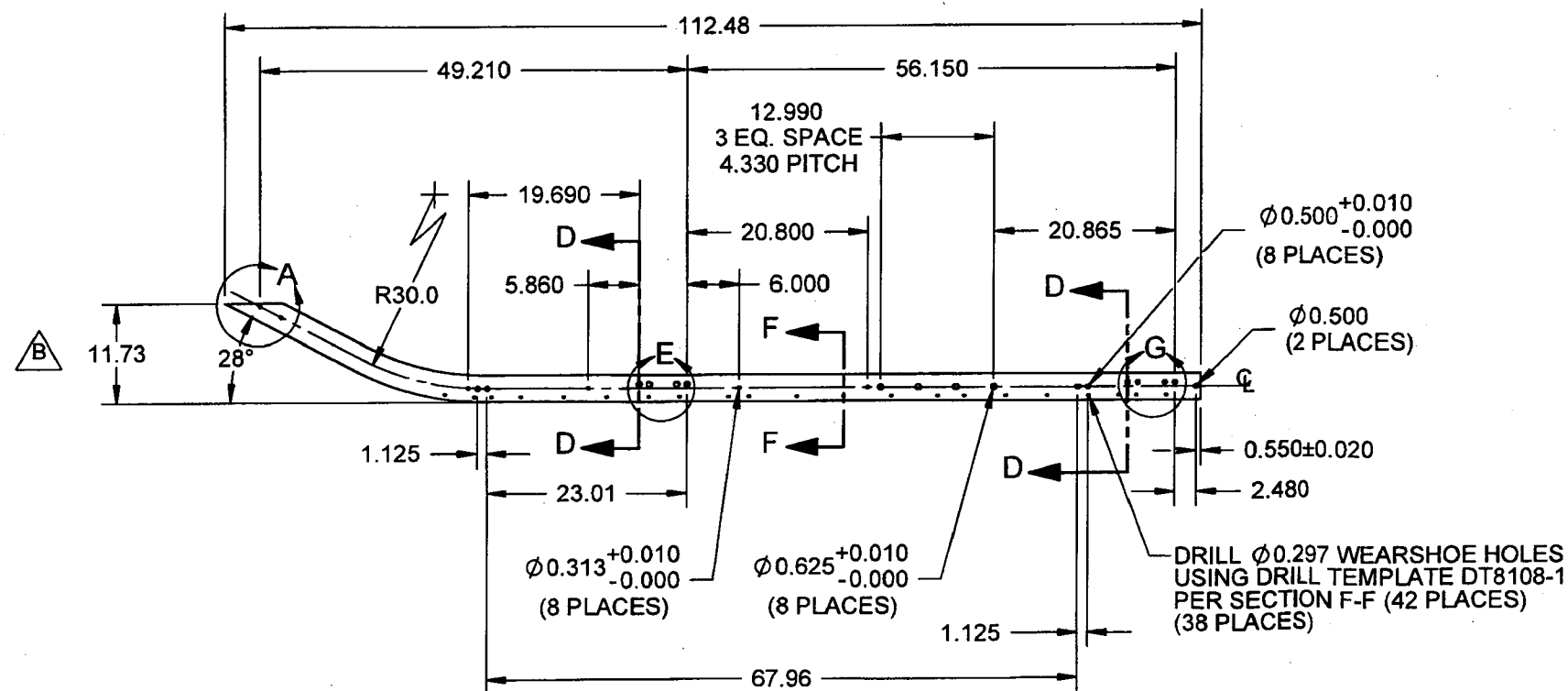
Qualifier Det Duval Date of Test Coupon 08-05-07

Welder Det Barclay Elliot Date of Test Coupon 08-05-07

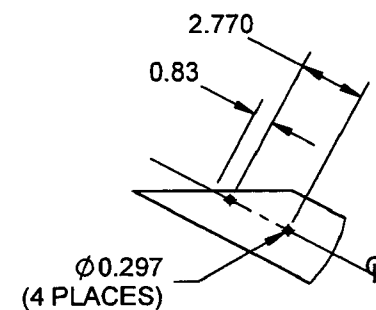
The above named individual is qualified in accordance with AWS D17.1.2001 to weld



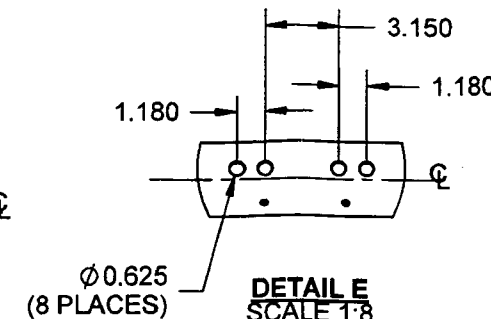
D2750-1 LH SKIDTUBE (SHOWN)
D2750-2 RH SKIDTUBE (OPPOSITE)



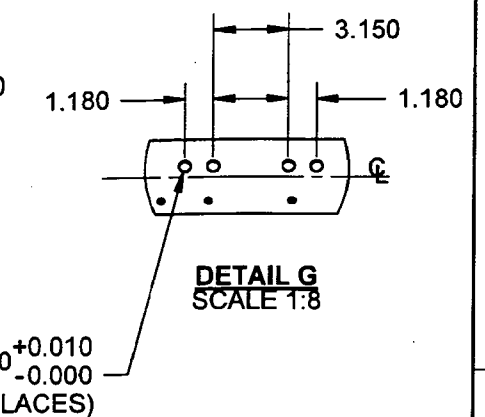
D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)



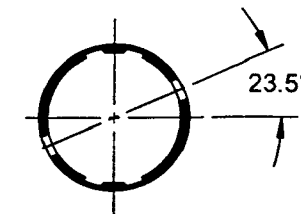
DETAIL A
SCALE 1:8



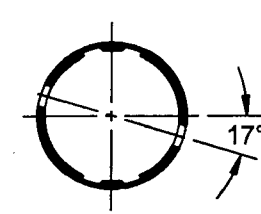
DETAIL E
SCALE 1:8



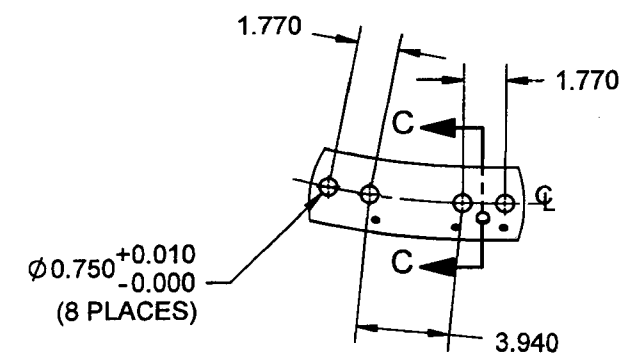
DETAIL G
SCALE 1:8



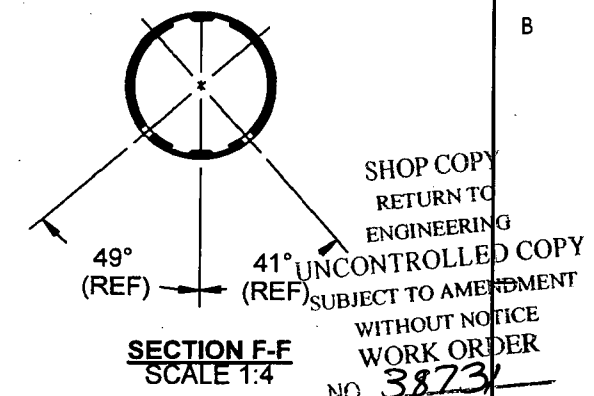
SECTION C-C
SCALE 1:4



SECTION D-D
SCALE 1:4



DETAIL B
SCALE 1:8
(ALL DIMENSIONS ARE
STRAIGHT LINE DIMENSIONS)



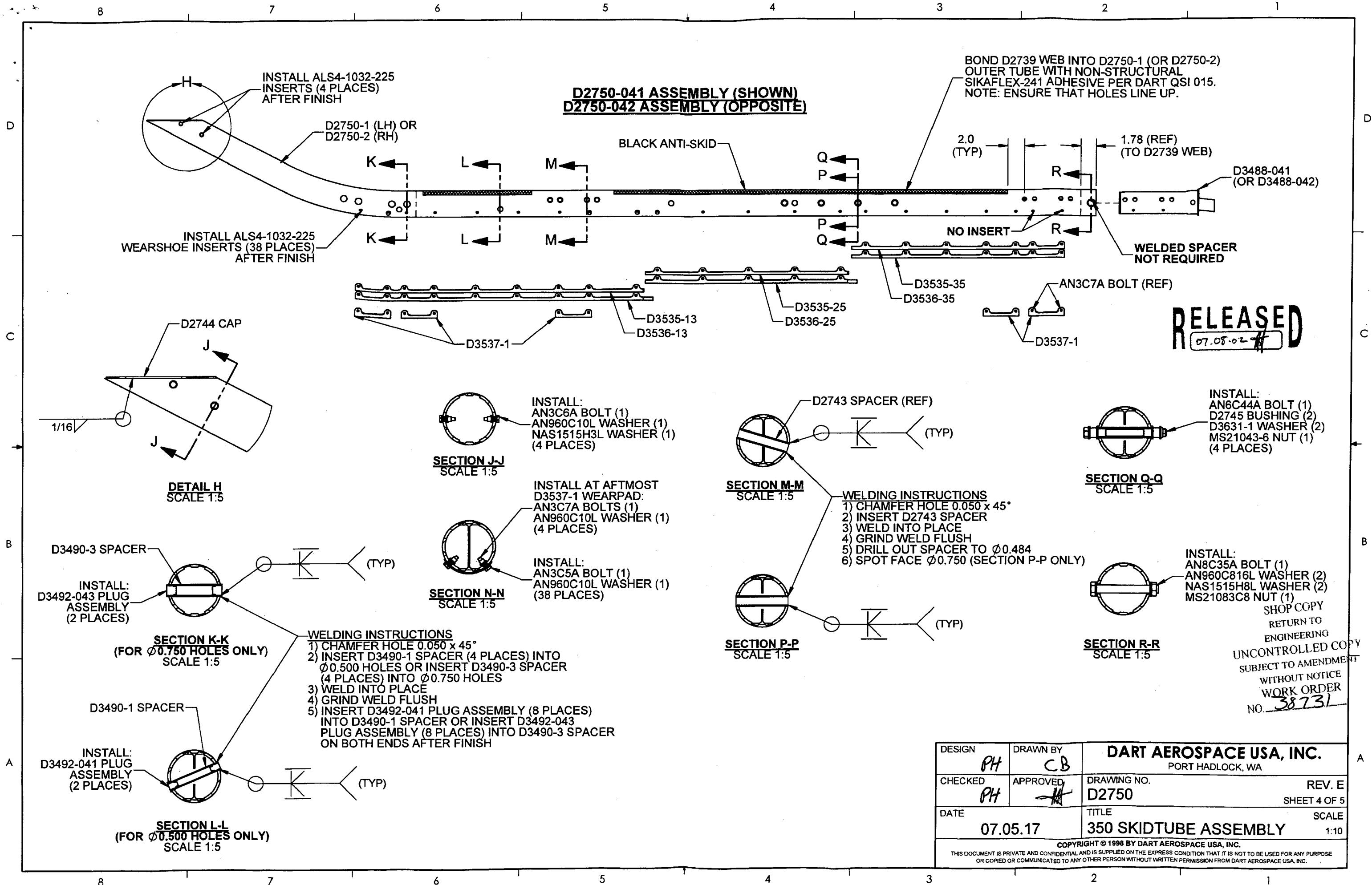
SECTION F-F
SCALE 1:4


RELEASED
07-08-02

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3873

DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2750	REV. E SHEET 3 OF 5
DATE 07.05.17	TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20	

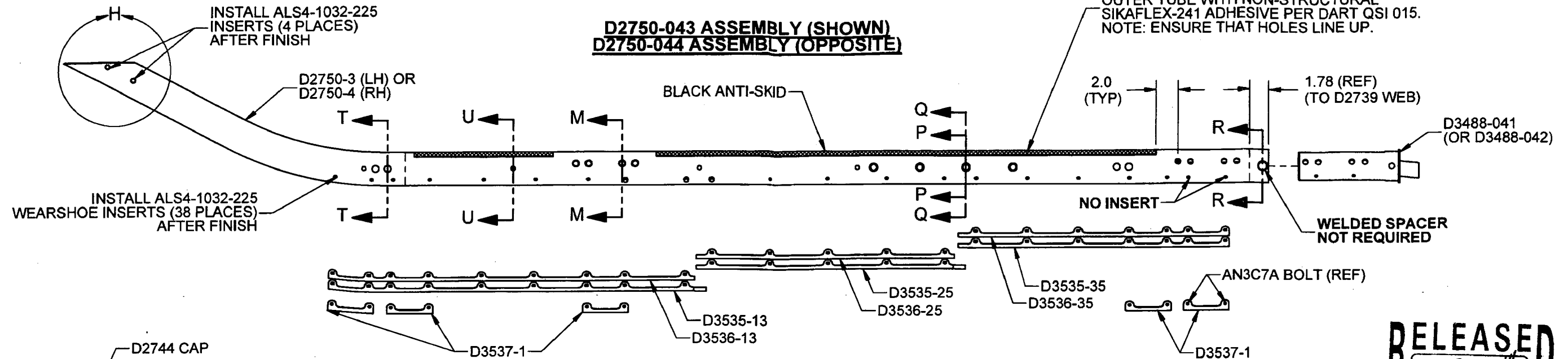
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



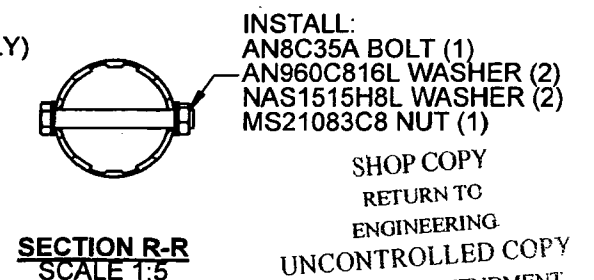
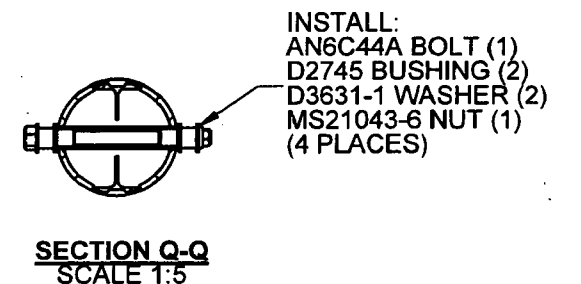
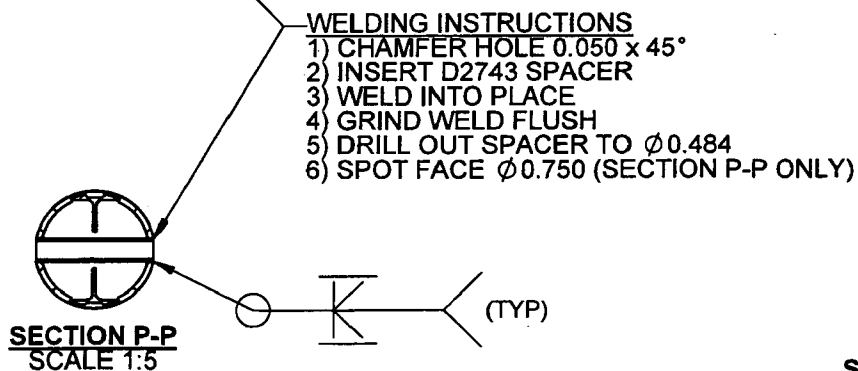
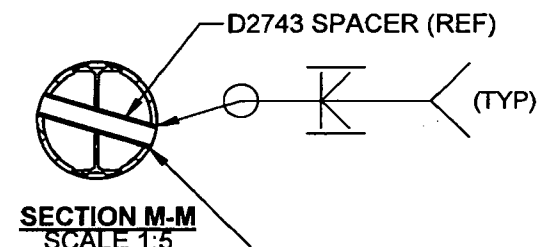
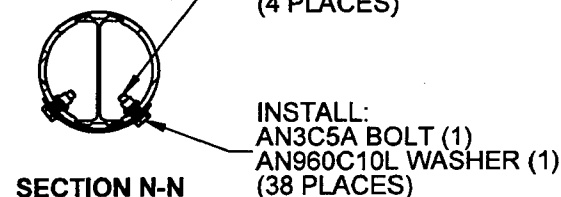
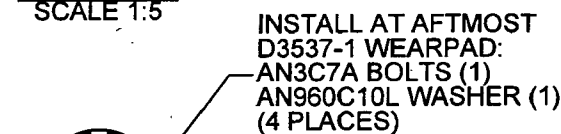
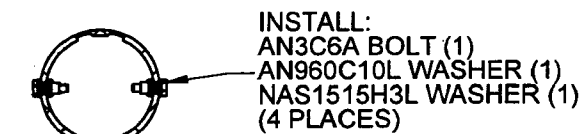
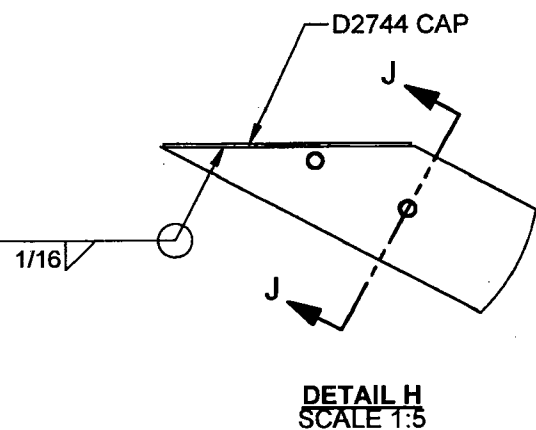
DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED 	DRAWING NO. D2750	REV. E SHEET 4 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:10
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

**D2750-043 ASSEMBLY (SHOWN)
D2750-044 ASSEMBLY (OPPOSITE)**

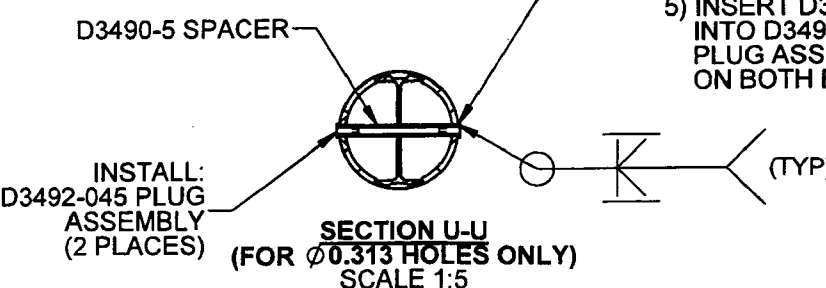
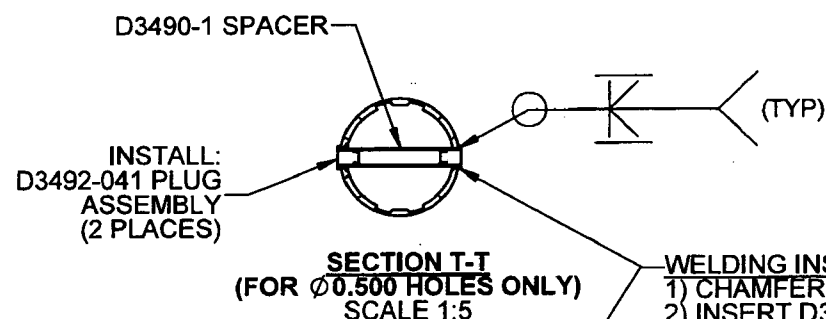
BOND D2739 WEB INTO D2750-3 (OR D2750-4)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.



RELEASED
07-08-02



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38731



- WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D3490-5 SPACER (4 PLACES) INTO
Ø0.313 HOLES OR INSERT D3490-1 SPACER
(4 PLACES) INTO Ø0.500 HOLES
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) INSERT D3492-045 PLUG ASSEMBLY (8 PLACES)
INTO D3490-5 SPACER OR INSERT D3492-043
PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER
ON BOTH ENDS AFTER FINISH

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 5 OF 5
DATE 07.05.17	TITLE 350 SKIDTUBE ASSEMBLY		SCALE 1:10
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

